

Date: Tuesday, 3/21/2006 11:00:39 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG  
Job Number : 26304  
Estimate Number : 12322  
P.O. Number : N/A  
This Issue : 3/21/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : N/A  
Written By : SEE COMMENT BELOW  
Checked & Approved By :  
Comment : est rev A 06.03.03 New Issue EC

Part Number : D3492041  
Drawing Number : D3492 REV.A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 3/28/2006 Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)

6061-T6 Round Bar .500"

(M6061T6R0500)

Batch: M17296

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492

Dwg Rev: A

Folio Rev: A

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAD 06.03.23

46

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 06/07/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 26304

Part Number: D3492041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 05 30

(44)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

DL 06/05/30

(44)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06-05-31

(44)

9.0 NAS1611010 O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

M100761X22  
M101334X6

DL 06/07/05  
DL 06/06/07

(28)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M101223

DL 06/07/05

(28)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 06/07/05

(28)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP 18

DL 06/07/05

(28)

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/07/05

(28)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



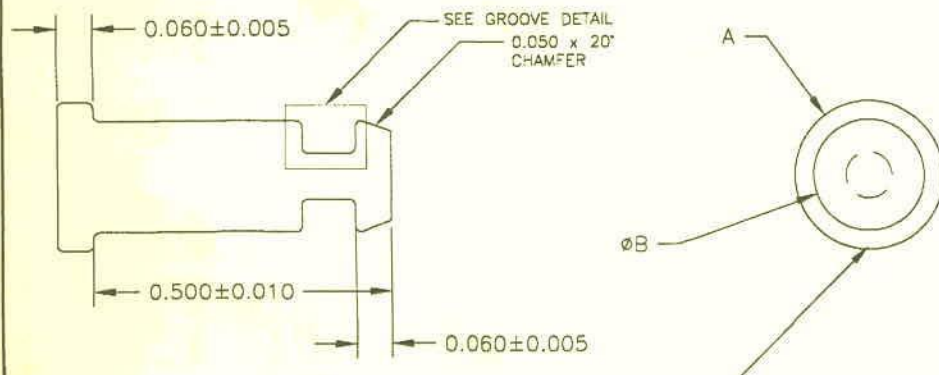


D3492-1 - 5 from  $\phi 1/2$ " stock  
D3492-3 from  $\phi 3/4$ " stock

X. 287  
Z. 002  
X. 305 2 - 050

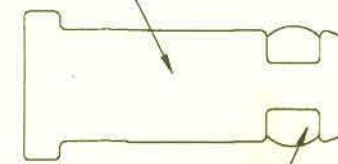
-018

(X. 376)



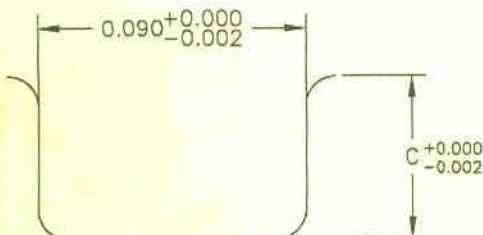
D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**



GROOVE DETAIL

**TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS**

| P/N     | A     | B     | C     | MATERIAL SPEC |
|---------|-------|-------|-------|---------------|
| D3492-1 | 0.500 | 0.394 | 0.055 | M6061T6R0.500 |
| D3492-3 | 0.625 | 0.582 | 0.045 | M6061T6R0.625 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.250 |

Done MS

Done MS

**D3492-1/-3/-5 PLUG NOTES**

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-D PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

P601-622  
Similar to D2651-1

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

| Qty -041 | Qty -043 | Qty -045 | Part Number | Description   |
|----------|----------|----------|-------------|---------------|
| X        |          |          | D3492-041   | PLUG ASSEMBLY |
|          | X        |          | D3492-043   | PLUG ASSEMBLY |
|          |          | X        | D3492-045   | PLUG ASSEMBLY |
| 1        |          |          | D3492-1     | PLUG          |
|          | 1        |          | D3492-3     | PLUG          |
|          |          | 1        | D3492-5     | PLUG          |
|          |          | 1        | NAS1611-003 | O-RING        |
| 1        |          |          | NAS1611-010 | O-RING        |
|          | 1        |          | NAS1611-013 | O-RING        |

11528775.007

Permanence P. 02/07/07 Int'l  
p/o 016

**RELEASED**  
06/02/07

|          |    |             |                               |
|----------|----|-------------|-------------------------------|
| A        |    | 06.01.04    | NEW ISSUE                     |
| DESIGN   | PH | DRAWN BY    | PH                            |
| CHECKED  |    | APPROVED    | DART DART AEROSPACE USA, INC. |
| DATE     |    | DRAWING NO. | REV. A                        |
| 06.01.04 |    | D3492       | SHEET 1 OF 1                  |
|          |    | TITLE       | SCALE                         |
|          |    | PLUG        | NTS                           |

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